

Work Order ID 59436

Friday, June 04, 2010 10:23:34 AM



Page 1

Item ID: D3911-3

Accept



Setup

Start



Revision ID:

Item Name: Aft Eyebolt Receiver

Stop



Start Date: 6/4/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: ☒

Date: 10-6-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3911

C

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank to 2.885" long

28 10/06/08

10

2

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-MILL as per folio FA917 & dwg,
FOLIO REV: AA
DWG REV: C

28 10/06/28
28 10/06/29

10


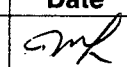


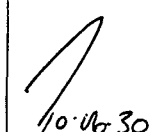
1

PTO

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3911-3 PAR #: _____ Fault Category: machining NCR: Yes No DQA: _____ Date: 10/07/08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/07/08

NCR: <u>59436</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/06/29	110	1 part scrap the thickness are too small. operator forget to remeasure the tool. This was the 0.080" wide dim A-A. R.L. L.O.A.		destroy and replace Batch # 1113310 Qty: 1 M113310	 10/06/29	 10/06/30	 10/06/29	 10/06/30

NOTE: Date & initial all entries

Work Order ID 59436

Friday, June 04, 2010 10:23:34 AM

Page 2

Item ID: D3911-3

Accept

Revision ID:

Item Name: Aft Eyebolt Receiver

Start Date: 6/4/2010 Start Qty: 20.00

Required Date: 6/10/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 090

0.00



Packaging

Memo

0.00

Packaging



Setup

Start

Stop

Cust Item ID:

Customer:

Run

Start

Stop

MW 10/06/29

MW 10/06/30

10

8

P/L 10/4/30 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59436

Friday, June 04, 2010 10:23:34 AM



Page 3

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Item Name: Aft Eyebolt Receiver

Stop



Start Date: 6/4/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/30 J

MF

10-6-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 10:23:40 AM

Page 1

Work Order ID: 59436



Parent Item: D3911-3



Parent Item Name: Aft Eyebolt Receiver

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP RevA: New issue DD verified by:EC

IPP REV:B

Start Qty: 20.00

Required Qty: 20.00

AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	0.5862	0.26	5.473684			
303 BAR 2" X 1.750"													

Location

Loc Qty

Loc Code

MAT53

0.5862

113310

0.5862

115417

~~2.4066~~ 5.862

2.4066

2.8 10/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

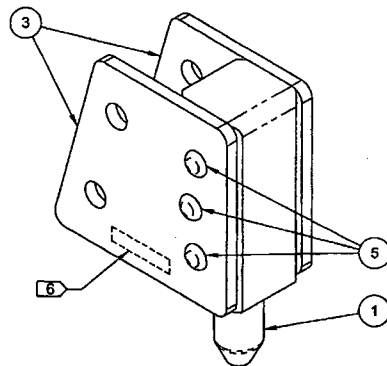
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

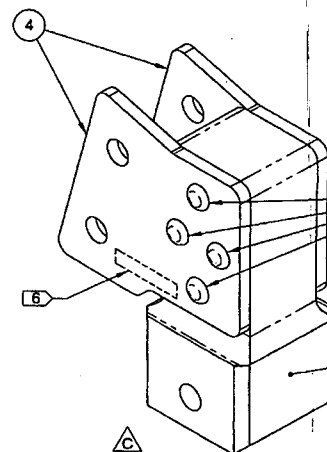
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 594136
2/10/06-04

RELEASED
2010-04-14
JPH

C	BOM: QTY (2): D4087-1 & MS21208-C810 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).		JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	JPH	DRAWING NO.	REV. C	
MFG. APPR.		D3911	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		AFT HARDPOINT, BASKET	NTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

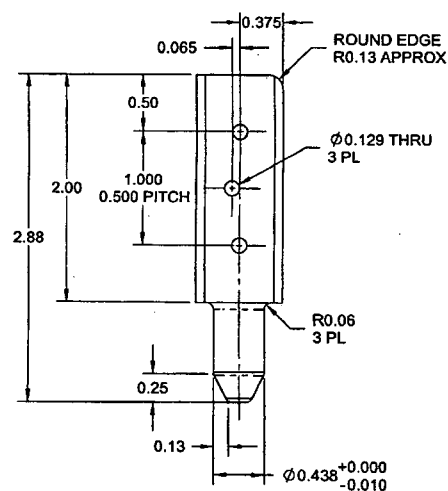
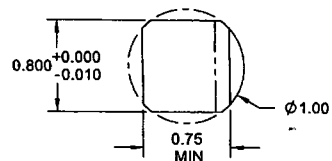
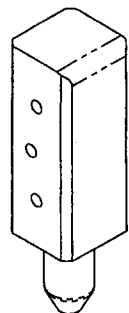
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

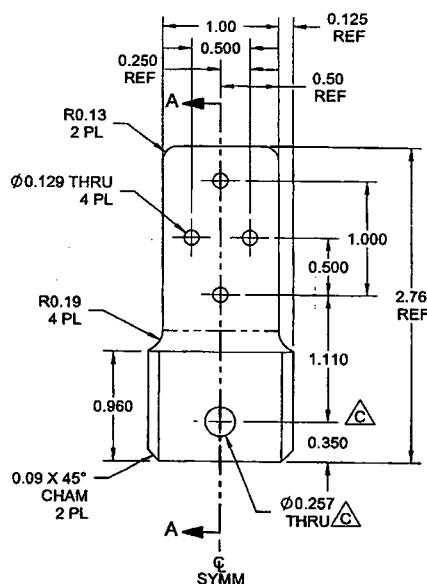
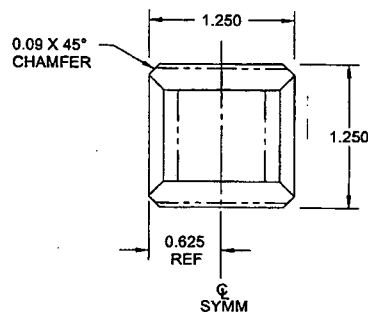
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

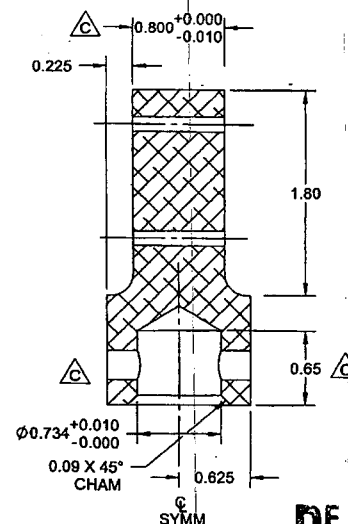
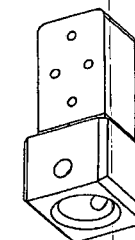
NOTE: Date & initial all entries



D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



SECTION A-A

RELEASED
2010-04-14

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.73 lbs

WU 59436

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3911	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT HARDPOINT, BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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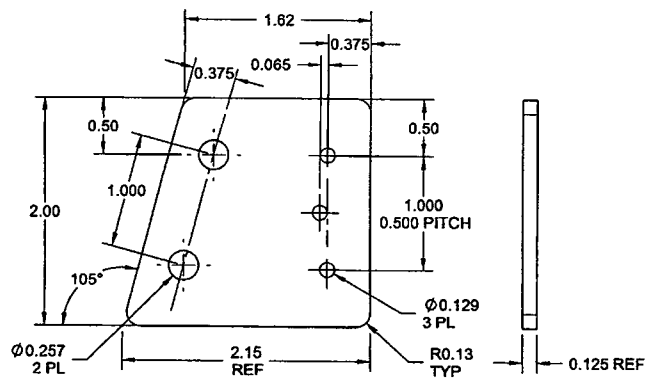
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

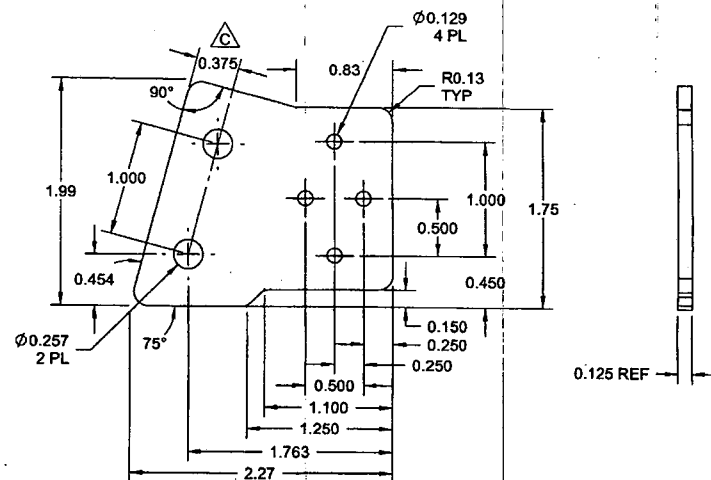
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3911-5 BASKET STUD PLATE



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

NOTES:

1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
PER DART SPEC M304S11GA OR M303S11GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs

w/o 59436

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3911
MFG. APPR.	<i>[Signature]</i>	REV. C SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE AFT HARDPOINT, BASKET
DE APPR.	<i>[Signature]</i>	SCALE NTS
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RELEASED
2010-04-14
[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries